

Date: Thursday, 02/04/2009 2:28:42 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 46882	
Estimate Number : 12403	
P.O. Number :	Part Number : D3511041
This Issue : 02/04/2009 S.O. No. :	Drawing Number : D3511 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 39768	Material :
Written By :	Due Date : 30/04/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JLD 09.04.03</u>	
Comment : Est Rev:A New Issue 06-05-04 JLM	
Est Rev:B New process 06-05-05 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S188	304 SHEET 0.188
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Comment: Qty.: 1.5572 sf(s)/Unit Total : 6.2286 sf(s)
 304 SHEET .188" THICK
 (M304S0188)
 Batch: 107875 IB 9-4-22

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3511
 Dwg Rev: A
 Prog Rev: A

IB 9-4-22

2-Deburr if necessary

IB 9-4-22

Identify as D3511-1

(8)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-4-22

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 09/04/22 (88)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:28:42 PM
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Process Sheet

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Drawing Name: WEARPLATE

Job Number: 46882

Part Number: D3511041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D35031	Cup
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

CUP

Batch: ~~5X B37770~~ 50 X B44638 29 X B46999

EL 9-4-23 (x64)

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend fwd 90 deg. bend per dwg D3511

PTO SB 09/04/22 (7)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/04/22 (x8)

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3511

A/R SS ROD Batch: M107051

EL 9-4-24 (x8)

9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3511

SB 09/04/28 (8)

10.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

CP 09-04-28

11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/04/28 (x8)

12.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

10:30

CMO/ EL

09/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3511-041 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/05/22

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46882</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09.04.22</u>	<u>6.0</u>	<u>QTY ① D3511-1 0.66</u> <u>IS 0.61.</u> <u>RC: SET UP</u>	<u>[Signature]</u> <u>09.04.22</u>	<u>ACCEPTABLE</u> <u>DEVIATION</u>	<u>[Signature]</u> <u>09/04/22</u>	<u>[Signature]</u> <u>09.04.22</u>	<u>[Signature]</u> <u>09.04.22</u>	<u>[Signature]</u> <u>09.04.22</u>

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:28:42 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 46882

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 320

FINISH TIME: 11:00

comp. Fd.

09/04/30

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ep



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-30

(X)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



(8x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 496A

9/5/1

SD

15.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

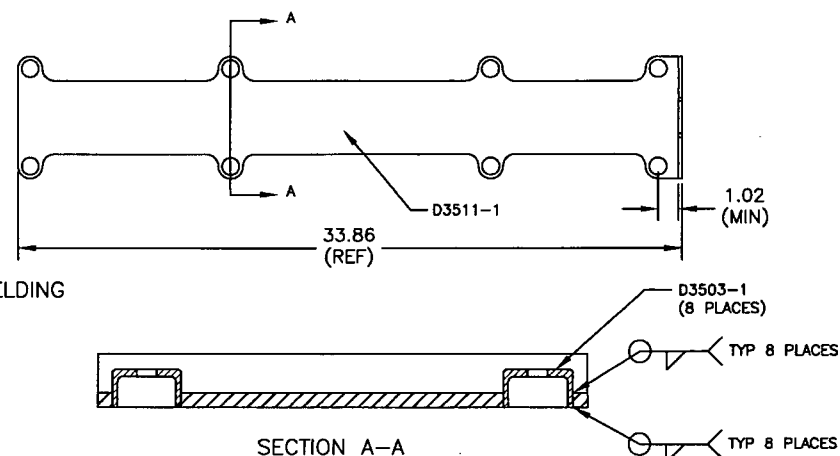
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

NOTE: BEND AFTER WELDING

D3511-1 BEND DETAIL



D3511-041 WELD DETAIL

1) MAKE D3511-1F WEARPLATE FROM: AISI 304/316 STAINLESS STEEL (0.188 THICK)
(REF DART MATERIAL SPEC. M304S7GA)

2) WELD PER DART QSI 004

3) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3

4) ALL DIMENSIONS ARE IN INCHES




5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED

D3511-041 WEARPLATE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
-1	D3511-1	WEARPLATE
2	D3503-1	CUP

A	06.04.04	NEW ISSUE	
DESIGN	PH	DRAWN BY	PH
CHECKED		APPROVED	
DATE	06.04.04	DRAWING NO.	D3511
		TITLE	WEARPLATE
		 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
		REV. A SHEET 1 OF 1	

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